

Work Order ID 56192

Page 1

February 12, 2010 10:38:03 AM

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-02-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	②	PLC 10-03-01
D3836	Rev A	Large Fab			
100			0.00		
Large Fab		1- cut D3836-1 and D3836-3 rib as per dwg D3836			
Large Fab		2- remove identification markings			
		3- deburr	SAD	10-02-24	
		4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836			
		5- weld D2327-3 spacer bushing as per dwg D3836 A/R ER316 S.S. Rod Batch: M109213			
		6- grind weld flush where indicated on dwg			

130



QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Quality Control

③

PLC 10-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 56192

Page 2

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC5- Inspect part completeness to step on W/O

0.00

S0103/01

0.00

QC

Quality Control

Memo

150



Identify as per dwg & Stock Location: WA

0.00

SAP 10-03-01

0.00

Packaging

Packaging

Memo

(2)
-040

(2)

160



QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Quality Control

Memo

10/03/03 JJ

MF
10-3-1

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Picklist Print

Page 1

February 12, 2010 10:38:08 AM

Work Order ID: 56192



Parent Item: D3836-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 2/12/10

Required Date: 2/18/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3 		Manufactured	No			100	Each	51.0000	2.0000			GT 10-03-01

Spacer Bushing

Warehouse

Location

Main Warehouse

ST	13	
44274	4	
44365	9	

Main Warehouse

WA	38	
55167	18	
55917	20	

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

100

f

473.1552 3.7491



SAN

10-02-24

Warehouse

Location

Main Warehouse

MAT	473.1552242	
113082	0.00419	
113245	0.00038421	
113683	16.30855	
113836	76.8421	
113956	380	

Main Warehouse

WA	0.0000047	
112398	0.0000047	

3.7491

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
 RETURN TO
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 56692
BS 10-2-12

RELEASED
08/11/RM

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>✓</i>	DART AEROSPACE LTD	
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	DRAWING NO. REV. A	
MFG. APPR.	<i>✓</i>	D3836 SHEET 1 OF 3	
APPROVED	<i>✓</i>	TITLE SCALE	
DE APPR.	<i>✓</i>	RIB ASSY (BASKET LID) NTS	
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION AND RESTRICTED IN THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.99 lbs EACH
 8) WELD PER DART QSI 004

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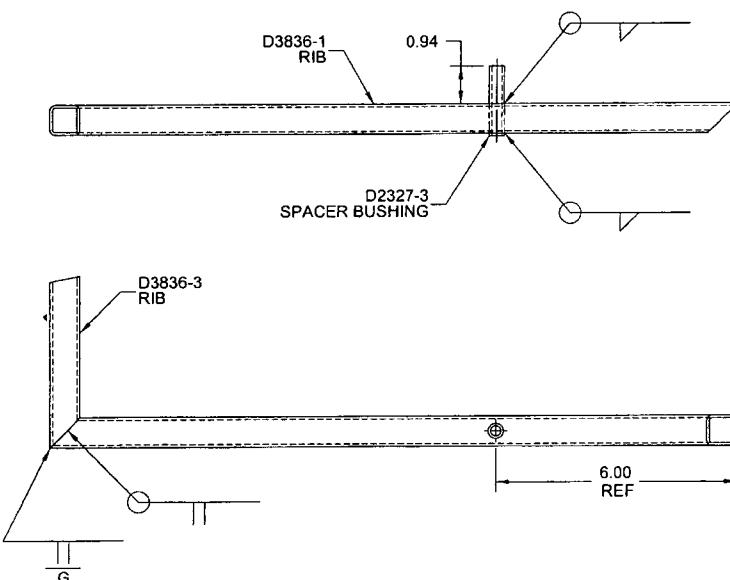
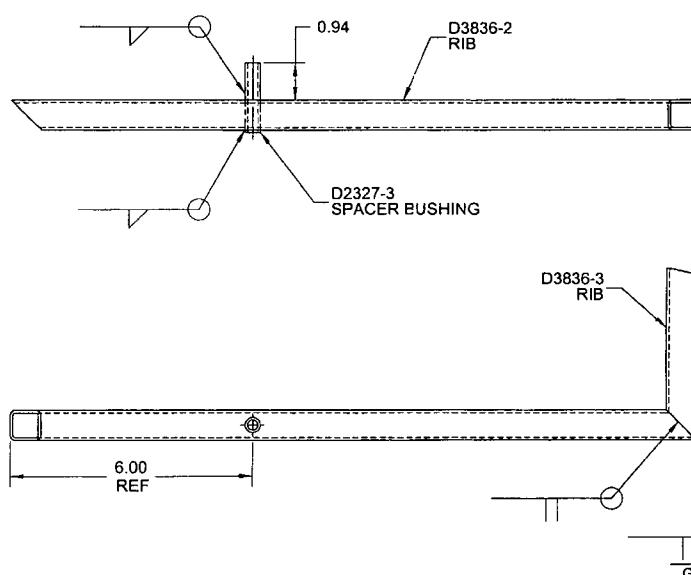
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8 7 6 5 4 3 2 1

D

D

D3836-041 RIB ASSY (BASKET LID, LH)D3836-042 RIB ASSY (BASKET LID, RH)

W/0 56192

RELEASED
08/11/18 M/T

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3836	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

A

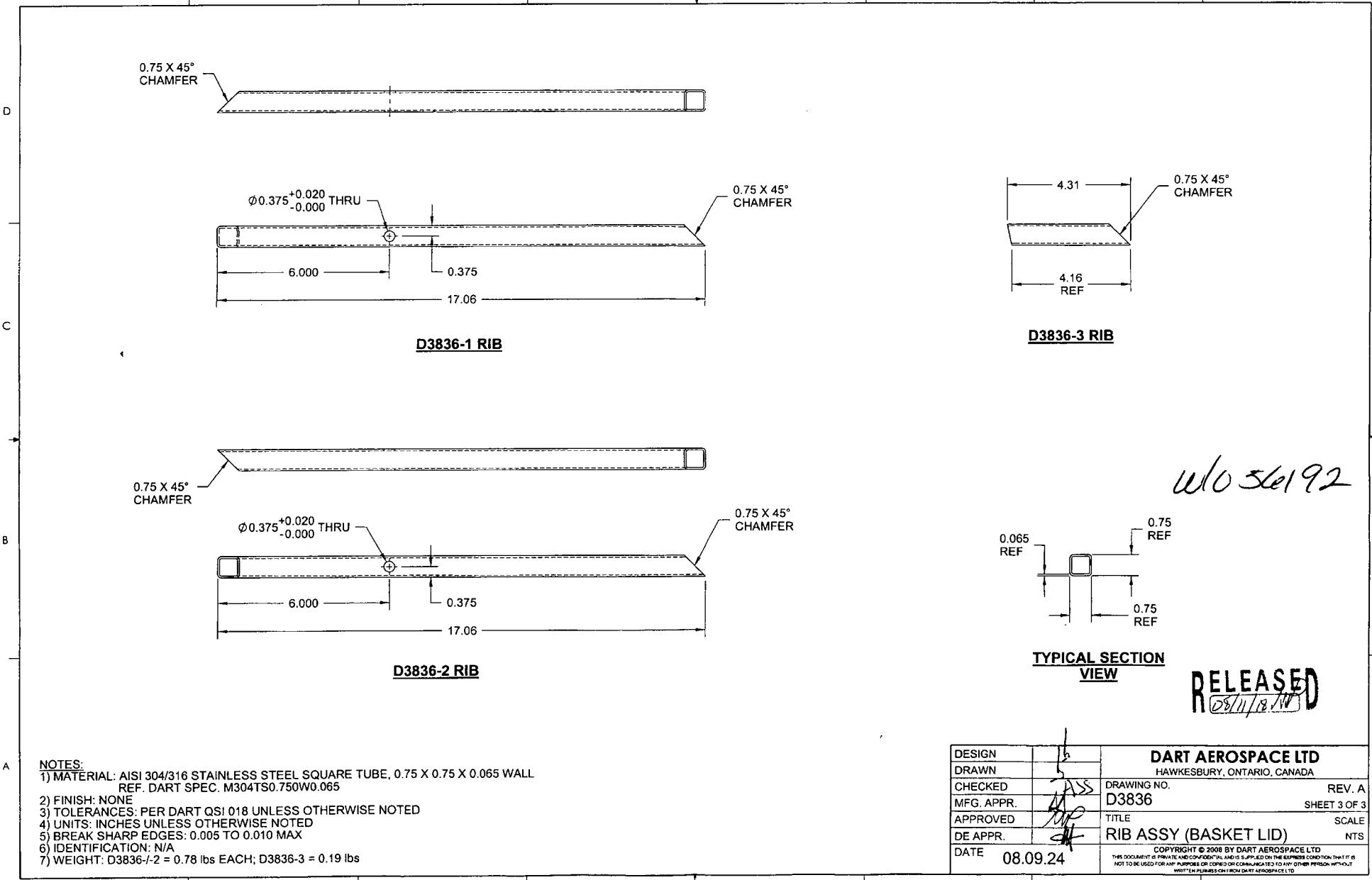
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